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Szekely

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(54) **CLOSURE WITH UNITARILY-MOLDED TAMPER-EVIDENT FEATURE**

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(22) Filed: **Sep. 8, 2011**

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(51) **Int. Cl.**

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B65D 43/18	(2006.01)
B65D 85/00	(2006.01)
B65D 51/20	(2006.01)
B65D 25/40	(2006.01)
B67B 1/00	(2006.01)

(52) **U.S. Cl.** **215/252**; 206/459.5; 215/230; 220/266; 220/254.4; 220/257.1; 220/259.3; 220/253; 222/541.5; 222/541.9; 222/153.06; 222/568; 222/548

(58) **Field of Classification Search** 215/250, 215/253, 230, 44; 220/256.1, 257.1, 257.2, 220/259.3, 259.4, 203.05, 203.16–203.18, 220/266; 222/568, 541.5, 541.9, 519–520, 222/153.01,153.05, 153.06, 153.1, 153.14, 222/566, 548, 567, 153.07, 96, 153.09, 411; 40/311; 206/459.5, 459.1

See application file for complete search history.

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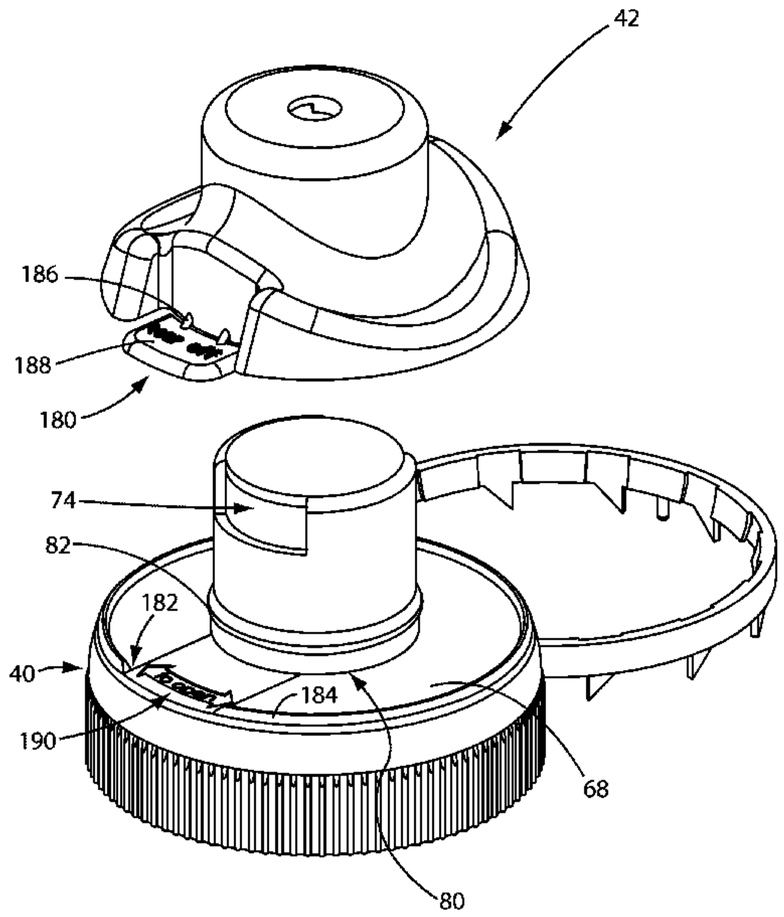
(57) **ABSTRACT**

A bottle closure includes the unitarily-molded combination of: an internally-threaded sidewall; a tamper indicator ring; and a hinge connecting the ring to the sidewall. The hinge permits the ring to be shifted from an initial position to an installation position. The installation position is essentially coaxially aligned with the sidewall.

11 Claims, 10 Drawing Sheets



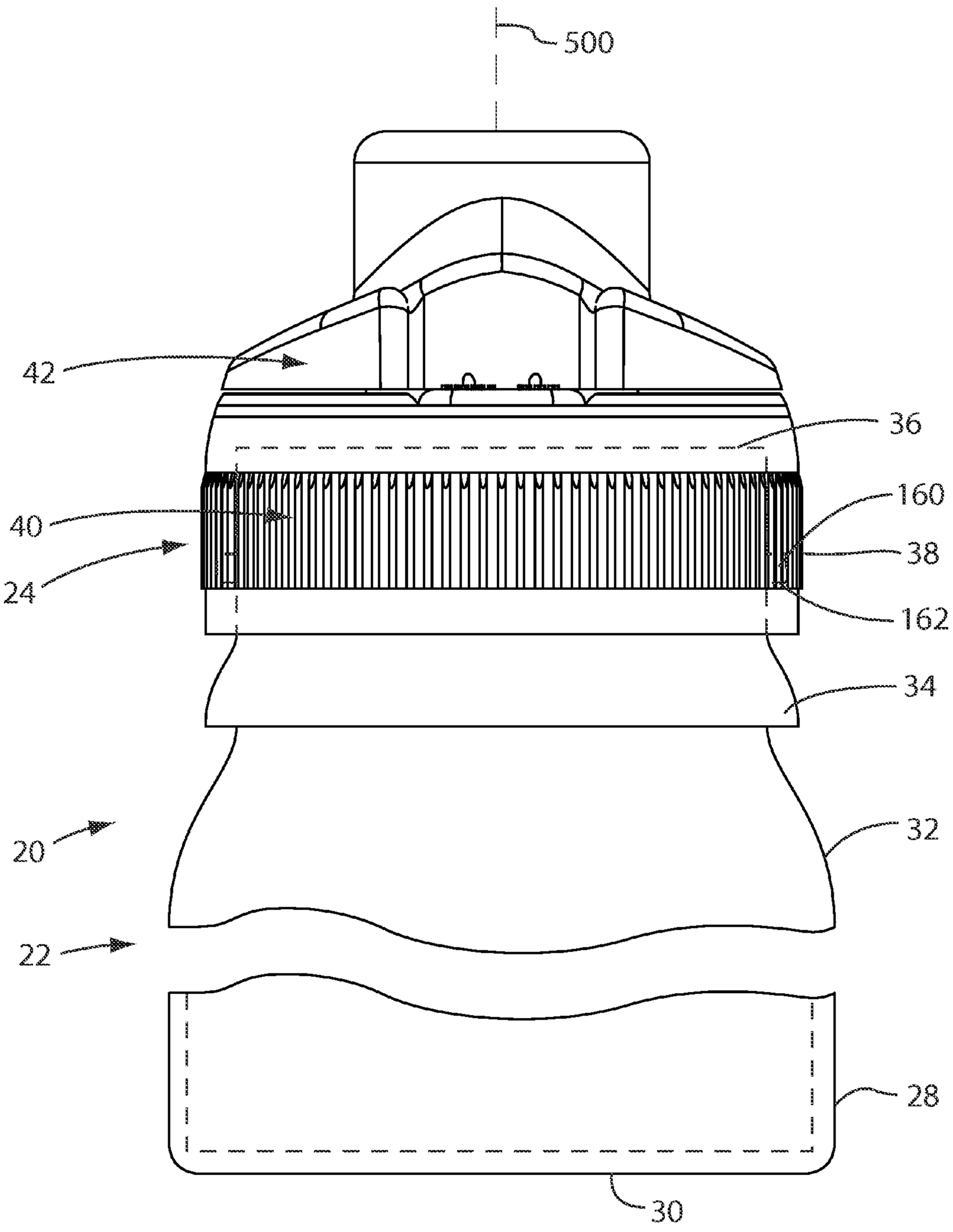


FIG. 1

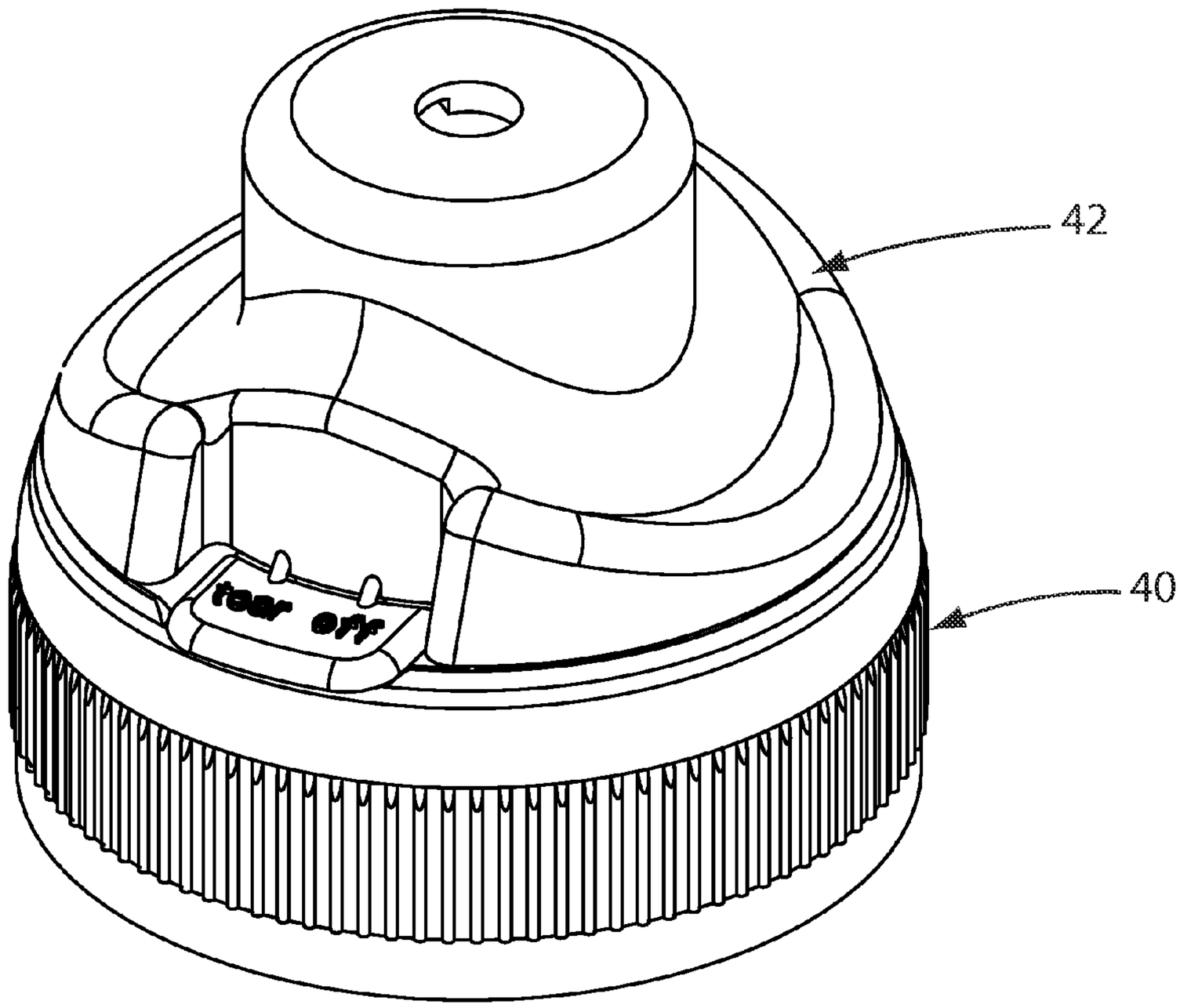


FIG. 2

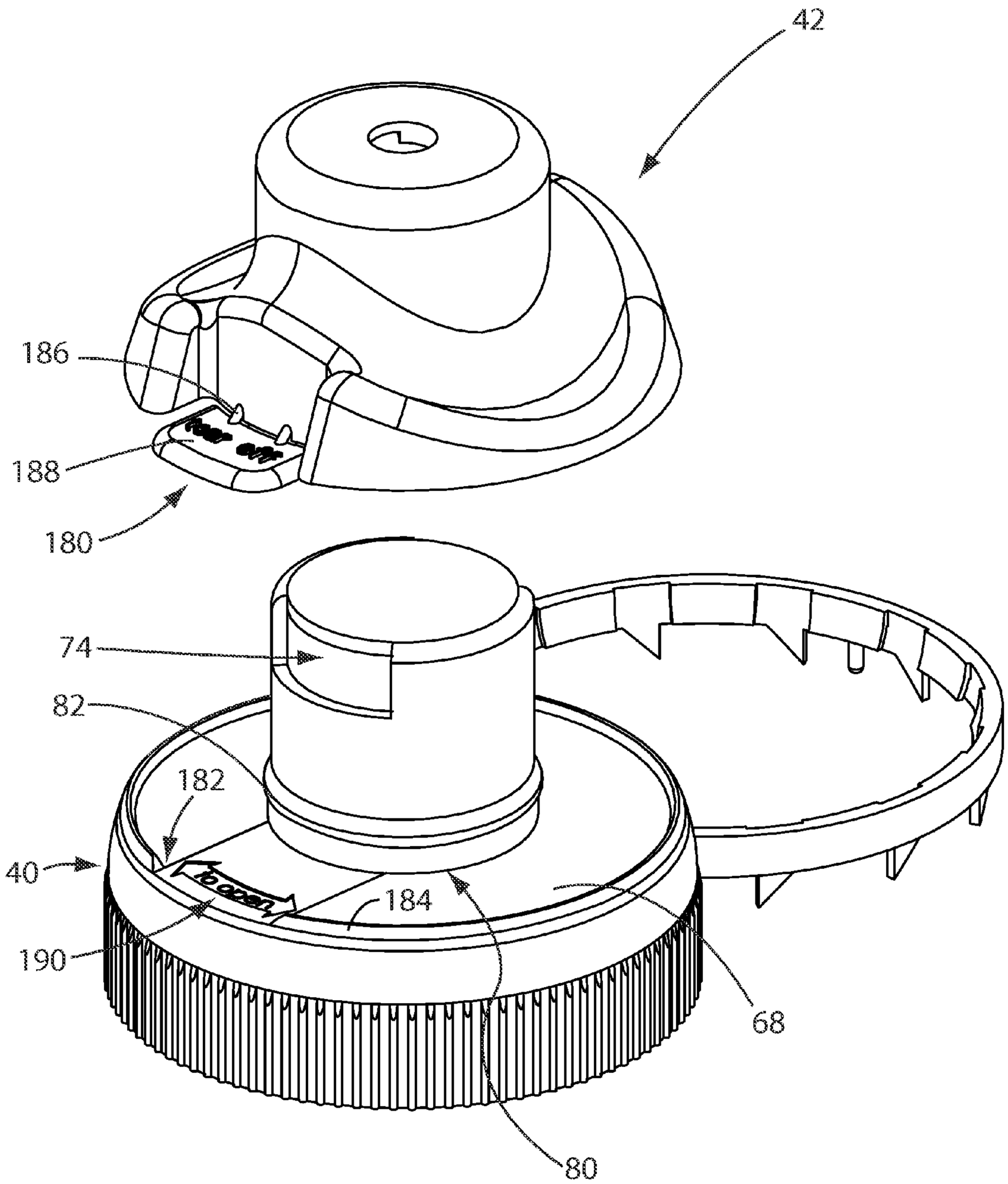


FIG. 3

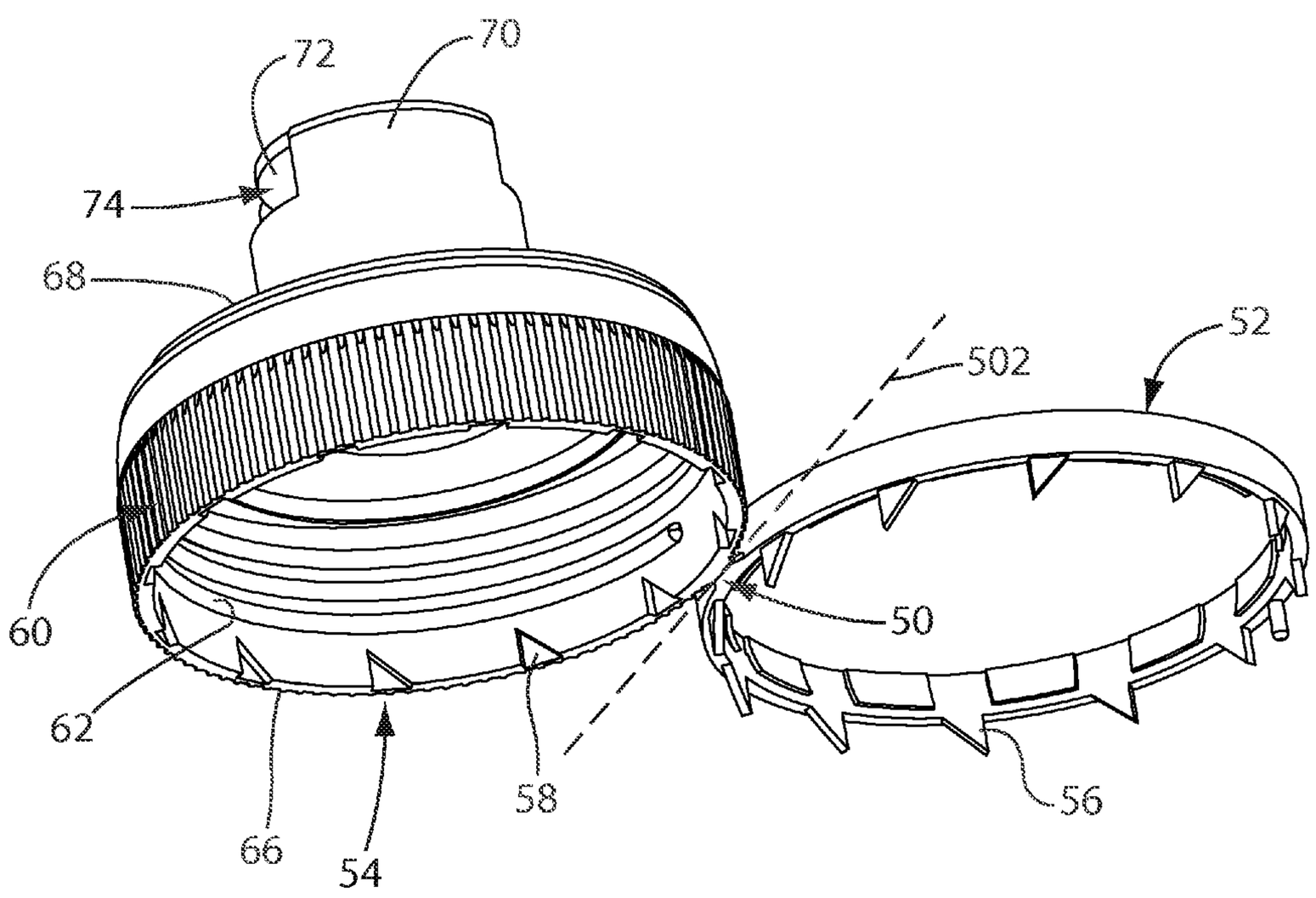


FIG. 4

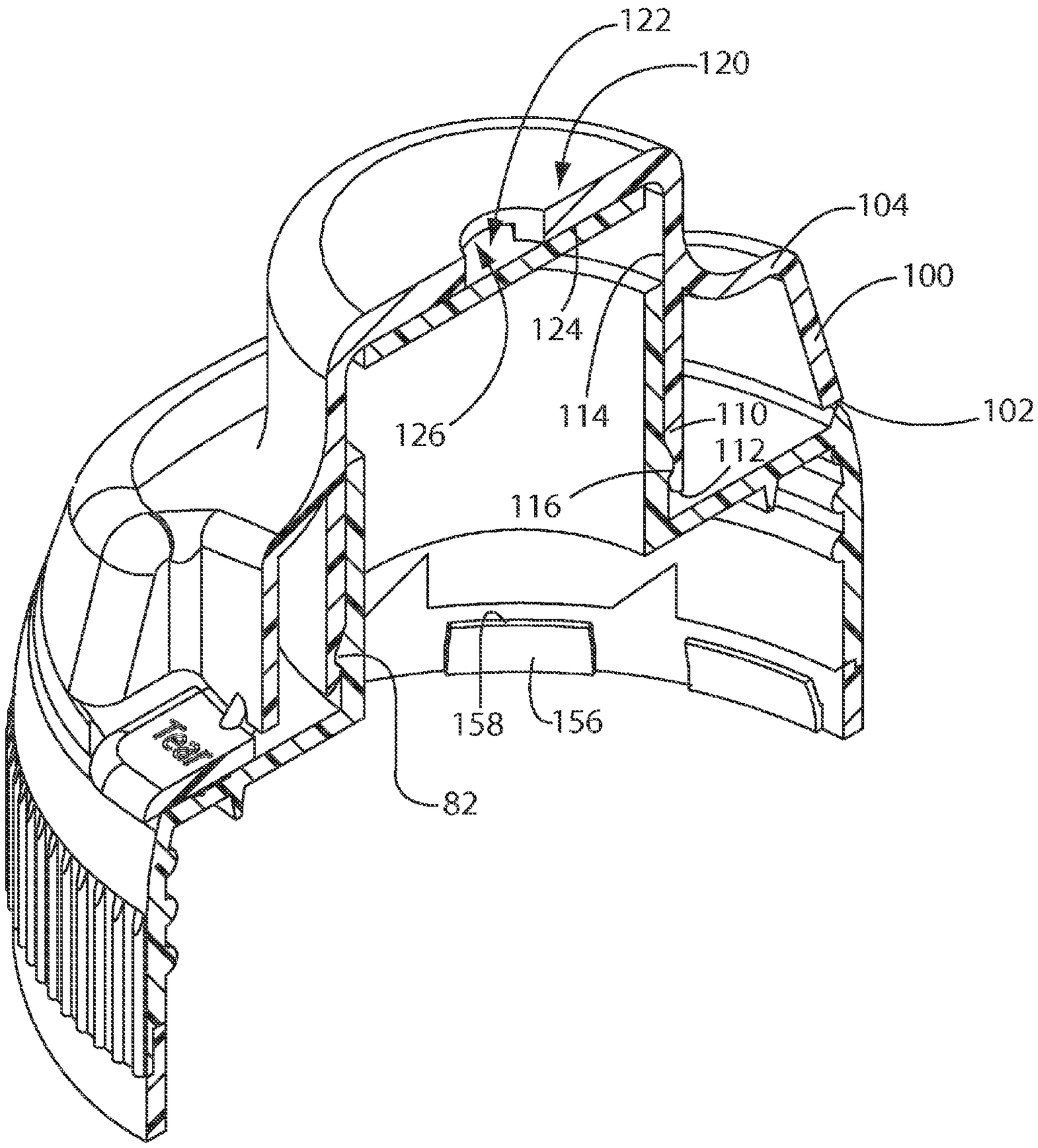


FIG. 5

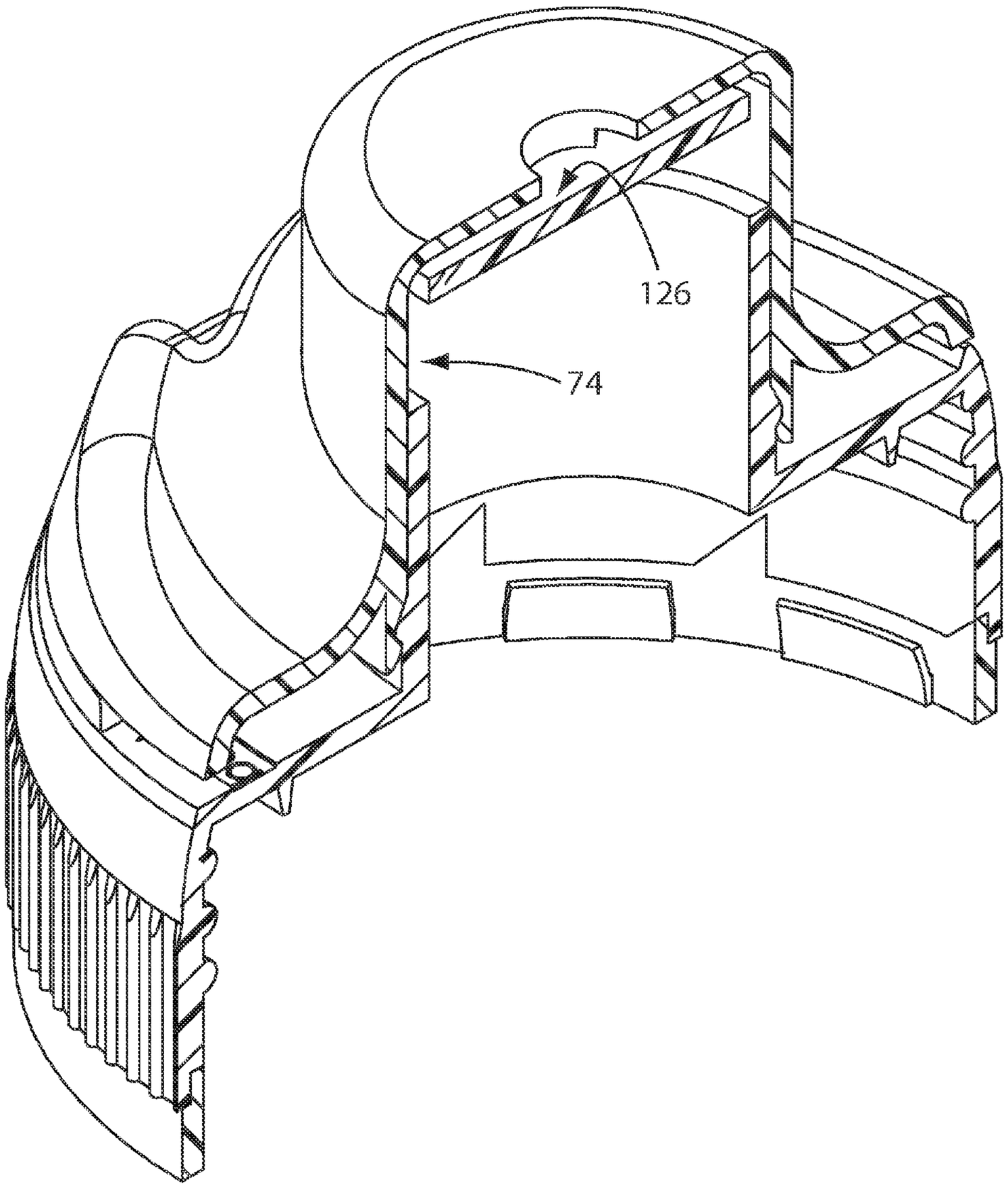


FIG. 6

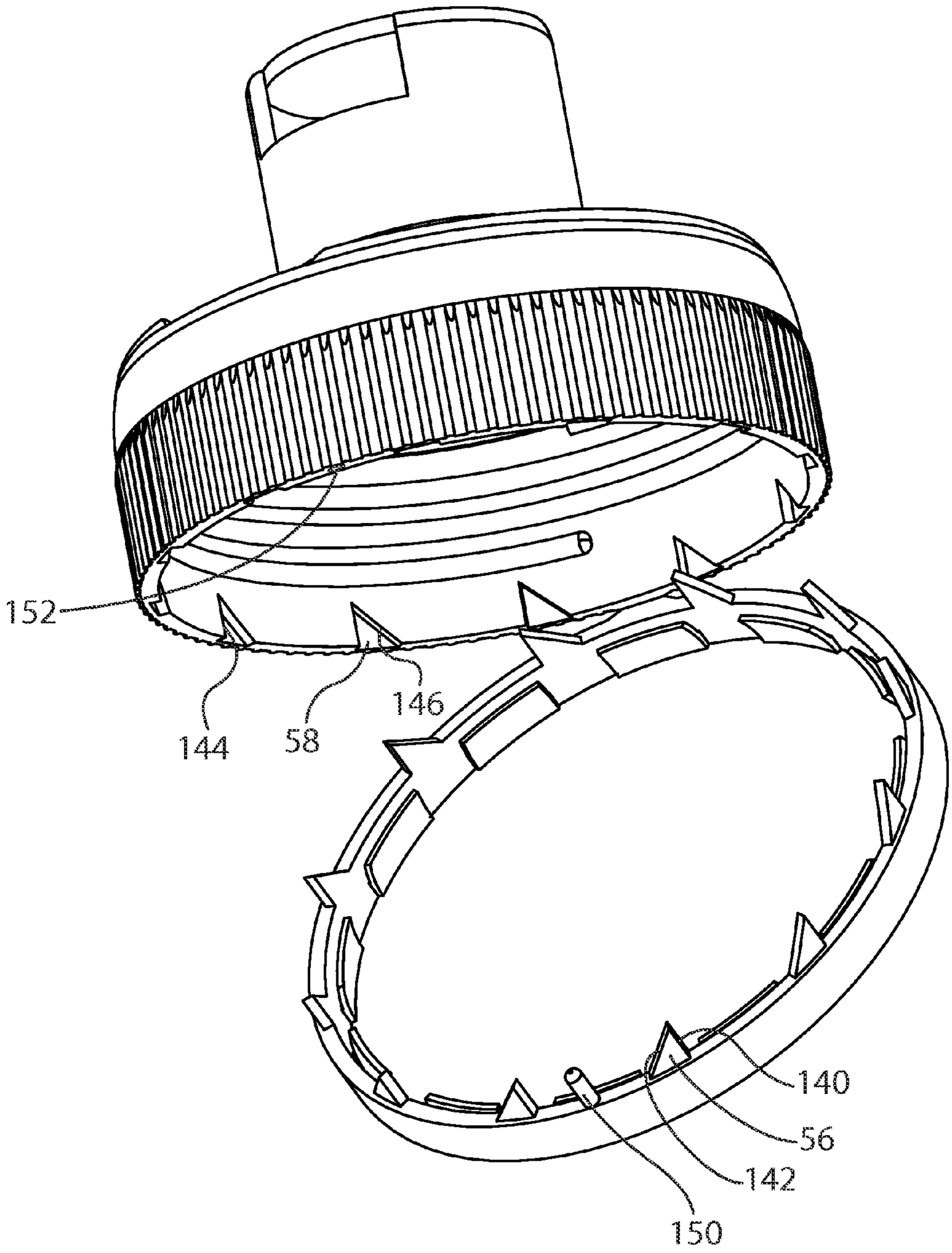


FIG. 7

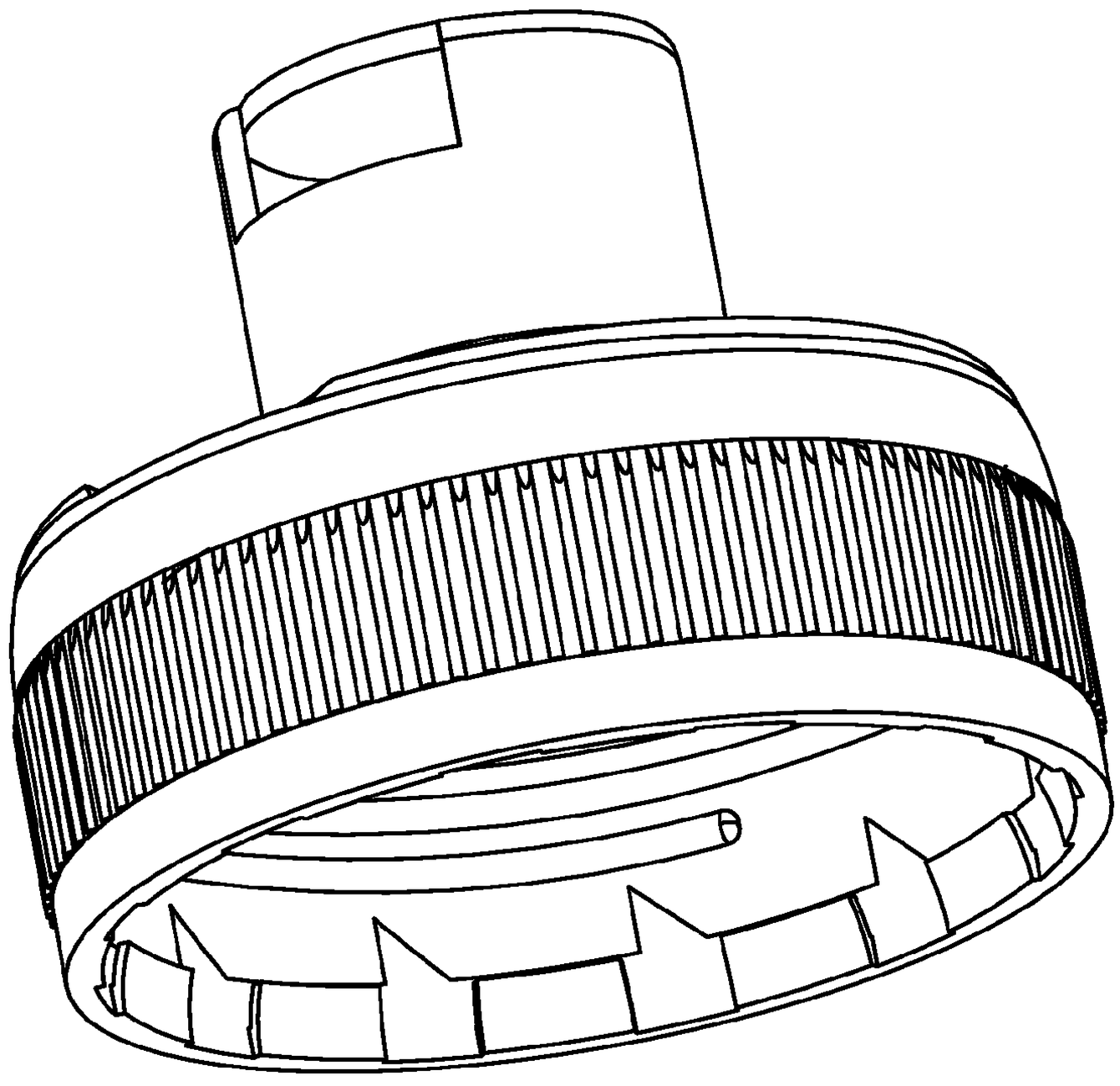


FIG. 8

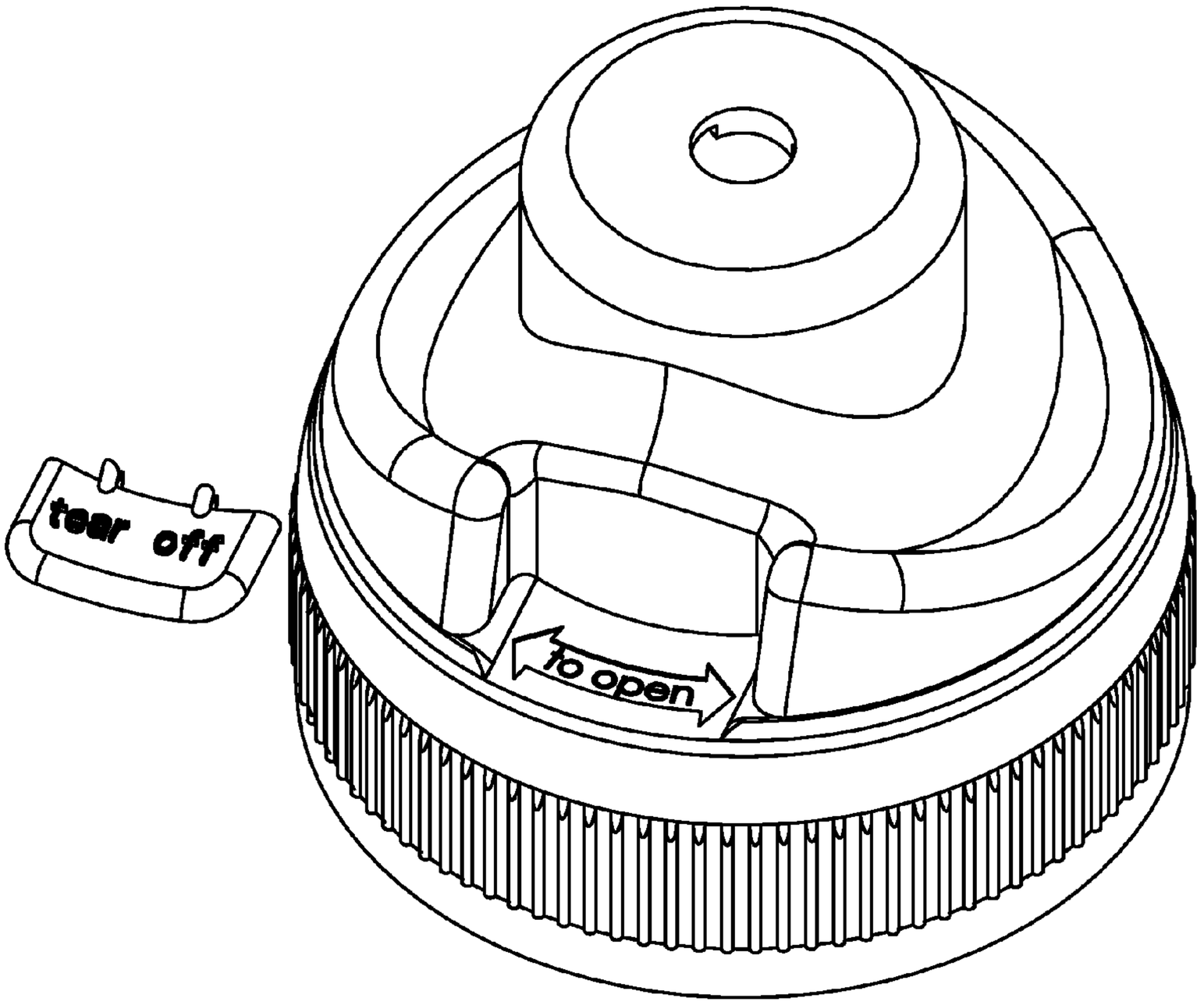


FIG. 9

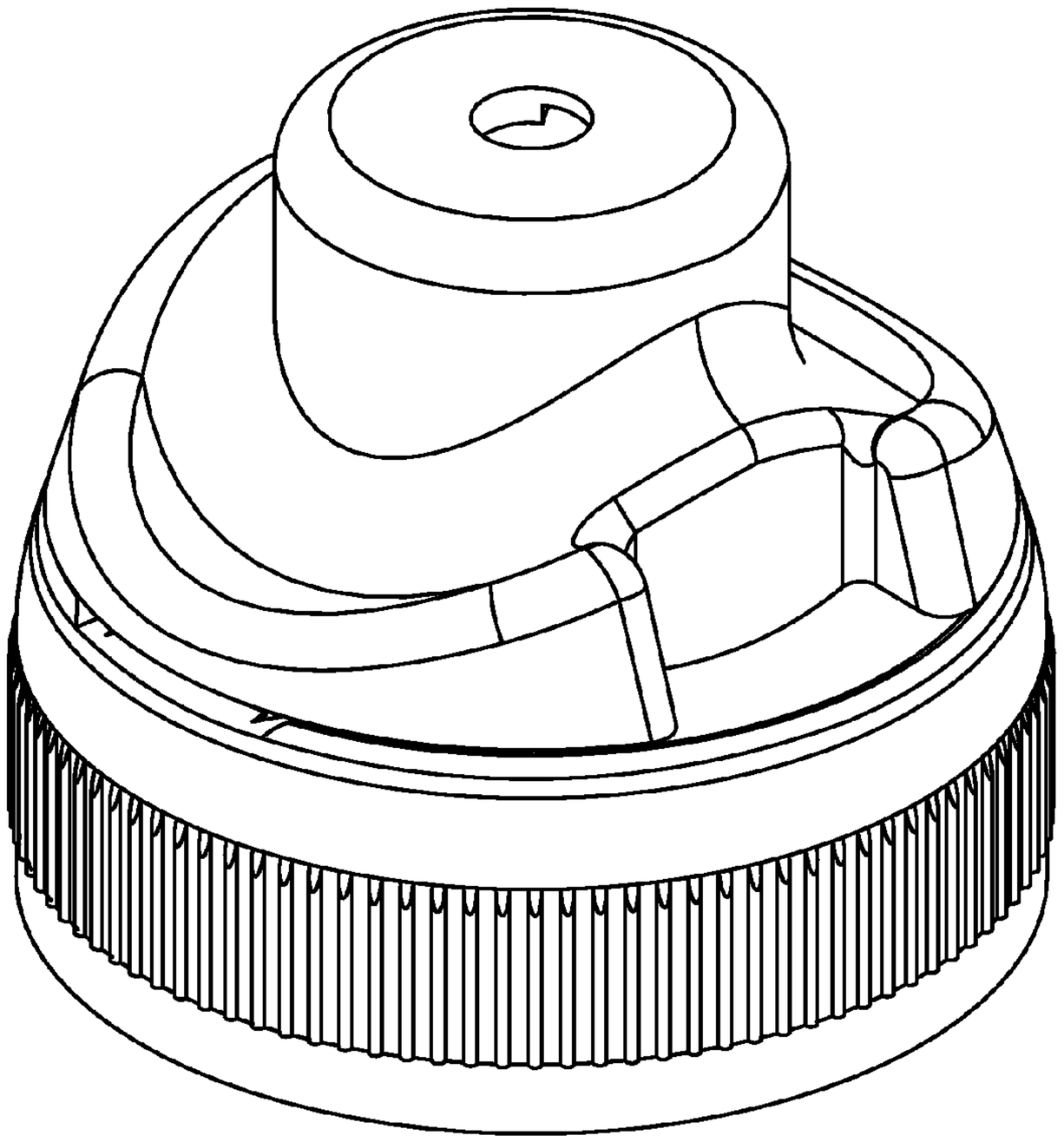


FIG. 10

CLOSURE WITH UNITARILY-MOLDED TAMPER-EVIDENT FEATURE

CROSS-REFERENCE TO RELATED APPLICATION

This is a divisional application of Ser. No. 11/627,544, filed Jan. 26, 2007, and entitled "Closure with Unitarily-Molded Tamper-Evident Feature", the disclosure of which is incorporated by reference herein in its entirety as if set forth at length, and benefit is claimed of Ser. No. 60/762,378, filed Jan. 26, 2006, and entitled "Tamper-Evident Closure", the disclosure of which is incorporated by reference herein in its entirety as if set forth at length.

BACKGROUND OF THE INVENTION

The invention relates to closures. More particularly, the invention relates to tamper-evident screw cap closures for bottles and the like.

A well-developed art exists regarding tamper-evident screw cap closures. A typical closure is molded of a plastic material (e.g., polypropylene, low density polypropylene (LDPE), or high density polyethylene (HDPE)). The closure body typically comprises an internally threaded sidewall portion. A bottom of the sidewall forms a tamper-evident ring. There may be an interrupted or otherwise weakened connection between the ring and adjacent portion of the sidewall. At the upper end of the sidewall main portion, a web may close the closure. Alternatively, any of a number of forms of open valve seat may be formed to which a separate valve element (e.g., a poppet) is movably mounted to open and close the closure.

The closure may be installed to a threaded neck of the bottle by screwing/threading. The screwing may flex/stretch the ring over the bottle external threads. Upon unscrewing of the closure, however, the tensile strength of the connection may be insufficient to draw the ring back over the bottle threads, thereby rupturing the connection and leaving the ring on the bottle. Even upon reinstallation of the remaining portion of the closure, the severed connection provides clear evidence that the closure has previously been opened.

The details of one or more embodiments of the invention are set forth in the accompanying drawings and the description below. Other features, objects, and advantages of the invention will be apparent from the description and drawings, and from the claims.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. **1** is a side view of a bottle.

FIG. **2** is a view of a closure of the bottle of FIG. **1**.

FIG. **3** is an exploded view of the closure of FIG. **2**.

FIG. **4** is a view of a main body of the closure of FIG. **2**.

FIG. **5** is a vertical sectional view of the closure of FIG. **2** in an initial closed condition.

FIG. **6** is a vertical sectional view of the closure of FIG. **2** in an open condition.

FIG. **7** is a view of the closure main body of FIG. **4** in an intermediate stage.

FIG. **8** is a view of the closure main body in a final stage.

FIG. **9** is a view of the closure in a closed condition showing a tamper evident tab removed.

FIG. **10** is a view of the closure of FIG. **9** in an open condition.

Like reference numbers and designations in the various drawings indicate like elements.

DETAILED DESCRIPTION

FIG. **1** shows a container (bottle) **20** as an assembly of a bottle body **22** and a closure assembly **24**. The bottle body **22** includes a sidewall **28** extending upward from a bottom or base **30**. The exemplary sidewall **28** extends to a shoulder **32**. A neck **34** extends above the shoulder to a rim **36** defining a mouth opening. The neck **34** includes an externally threaded portion **38** below the rim **36**. The bottle interior may contain a liquid beverage. The exemplary body **22** and closure **24** have a common central vertical/longitudinal axis **500**. The exemplary closure **24** is the assembly (main) of a first piece **40** and a second piece **42**. As is discussed further below, the exemplary first piece **40** forms a closure body and the exemplary second piece **42** forms a valve element which may be articulated relative to the closure body to open and close the bottle. An exemplary articulation is a relative rotation about the axis **500**. An exemplary bottle body **22** is of any conventional yet-developed type and may be unitarily molded from a plastic (e.g., HDPE). The exemplary closure body **40** may similarly be unitarily molded (e.g., of HDPE or MDPE). The valve element **42** may similarly be molded (e.g., of polypropylene).

The closure body **40** may be molded with a live hinge **50** joining a tamper-evident ring **52** to a main portion **54** of the closure body. The hinge **50** defines a hinge axis **502** transverse to and spaced-apart from the central axis **500**. First engagement features **56** and **58** on the ring and main body may facilitate screwing the closure body onto the bottle body.

The exemplary closure body **40** is a unitary molding. The exemplary main body **54** includes a sidewall **60** having an internal thread **62**. The sidewall **60** extends from a lower rim **66** to a shoulder **68**. A neck **70** extends upward from the shoulder to a top plate or web **72**. The neck includes a pair of radially opposed ports **74** below the web plate **72**. Near a base **80** of the neck **70**, the neck **70** includes a radially-projecting circumferential retaining rib/barb **82** (FIG. **3**) for retaining the valve element **42**.

The exemplary valve element **42** (FIG. **5**) includes an outer skirt or sidewall **100** extending upward from a lower rim **102** to a shoulder **104**. The shoulder **104** merges with an intermediate portion of an inner sidewall **110** extending upward from a lower rim **112**. The inner sidewall **110** includes an inner/interior surface **114**. The interior surface **114** includes a circumferential channel **116** positioned to mate with the rib/barb **82** when the valve element **42** is installed to the body **40**.

The exemplary valve element **42** includes a top web/plate **120** at the upper end of the inner sidewall **110**. The exemplary web **120** includes a central aperture/port **122**. The web **120** has an underside **124**. A diametric channel **126** extends along the underside **124** from the port **122**. The valve element may be installed to the main body **40** by a translation along the axis **500** to snap the channel **116** into engagement with the rib **82**. When installed, the underside **124** may contact the top surface of the web **72**. Installation may be in the closed orientation of FIG. **5** wherein the channel **126** is transverse to the ports **74** so that the bottle is sealed by cooperation of the webs. An opening procedure, described in further detail below, rotates the channel **126** into alignment/communication with the ports **74**. Alternative valves may open by shifts including a translation or a different rotation.

The body **40** and valve element **42** of the closure **24** may be preassembled to each other and installed to a filled bottle body **22**. Alternatively, the closure body **40** may be installed to the

bottle body and the bottle may then be filled through the ports **74**. Thereafter, the valve element **42** may be installed.

FIG. **4** shows the closure body **40** in an approximate as-molded condition. To install the closure body **40** to the bottle main body **22**, the ring **52** is rotated about the axis **502** of the hinge **50**. FIG. **7** shows an exemplary intermediate stage of that rotation. FIG. **8** shows a final condition. An exemplary rotation is approximately 180° (e.g.,)170°-190°. The final stage of the rotation brings the features **56** and **58** into engagement with each other. Exemplary features **56** are sawtooth projections having first edges **140** and second edges **142**. Exemplary features **58** are complementary sawtooth recesses in the interior surface of the sidewall **60** extending upward from the lower rim **66**. Exemplary recesses **58** include first edges **144** and second edges **146**. The exemplary rotation also brings a locator/retention pin **150** extending from the upper rim of the ring into engagement with a complementary socket **152** extending upward from the lower rim **66**. Engagement of the pin **150** with the socket **152** may serve to hold the ring in the FIG. **8** orientation prior to mounting on the bottle main body (e.g., or transport to the bottling line and handling during automated assembly on the line).

As is discussed further below, the exemplary edges **140** and **144** are sufficiently close to vertical or over vertical so as to permit a driving engagement. Specifically, with the projections **56** accommodating the recesses **58**, the closure main body may be screwed onto the bottle main body. The engagement causes inward barb projections **156** having upper trailing edges **158** (FIG. **5**) to pass over a complementary rib **160** on the bottle neck so that the trailing edges **158** snap into abutting engagement with an underside **162** of the rib. Thereafter, an unscrewing motion will produce one or more of several effects. The engagement between the projections **156** and rib **160** will tend to hold the ring in place as the closure main body **54** is lifted upward by the unscrewing. The relatively shallower angle of the edges **142** and **146** will hinder the transmission of torque between the closure main body **54** and ring **52** and will tend to jack the closure main body **54** off the ring **52**. The result will be to sever the live hinge **50** and provide evidence of removal of the closure main body from the bottle.

Such a hinged tamper-evident ring may have one or more of several advantages relative to conventional tamper-evident rings. By at least partially decoupling the frangible/severable connection (e.g., the hinge **50**) from the rotation-transmitting connection (e.g., principally the projections **56** and recesses **58**), the ring may be much more easily severed. This may increase the reliability of severing the ring when the closure is removed. This is particularly relevant as both bottles and closures become more compliant (e.g., use of softer materials and/or thinning to reduce resource consumption). Also, sensitivity to manufacturing variations may be reduced (e.g., age and wear of molding dies may have a reduced influence on severability of the ring).

The closure assembly may also have a feature for evidencing an attempted opening of the closure assembly (e.g., of the valve element **42** while the closure body **40** remains installed). The exemplary valve element **42** is opened by a rotation relative to the closure body **40** about the axis **500**. Exemplary rotations are approximately 90° in either direction. Such a rotation brings the channel **126** into alignment and communication with the ports **74** (FIG. **6**). Thus, evidencing the rotation will evidence the opening.

To evidence the valve element rotation and opening, the exemplary closure includes a breakaway tab **180** (FIG. **3**) on one of the closure body **40** and valve element **42** which is received by a complementary feature **182** in the other. An exemplary tab **180** is a flat horizontal radially-projecting tab on the valve element **42**. An exemplary complementary feature **182** is a recess in a rim **184** at the outer diameter (OD) of the shoulder **68**. The exemplary tab **180** includes frangible connections **186** to the remainder of the valve element. The exemplary tab **180** has an upper surface **188** having instruction indicia indicating that the tab must be torn or pulled off by rupturing the connections **186**. In the exemplary embodiment, removal of the tab **180** reveals indicia **190** on the shoulder **68** providing instructions to open the valve by rotation in either direction (e.g., a bidirectional circumferential arrow and the word "open"). With the tab **180** in place, engagement with the mating feature **182** prevents or otherwise resists the opening rotation. The indicia **190** may also include express indicia identifying that the product has been opened.

One or more embodiments of the present invention have been described. Nevertheless, it will be understood that various modifications may be made without departing from the spirit and scope of the invention. For example, when implemented as a reengineering of an existing closure and/or for use with an existing bottle body, details of the existing closure or bottle body may influence or dictate details of the particular implementation. Accordingly, other embodiments are within the scope of the following claims.

What is claimed is:

1. A bottle closure comprising:

a main body comprising a first piece having an internally-threaded sidewall for engaging a bottle external thread; and

a valve element comprising a second piece mounted to the main body for shifting between open and closed conditions,

wherein:

in an initial condition, a first of the main body first piece and valve element second piece has an integrally formed tab engaged by a complementary feature of the other of the main body first piece and valve element second piece, the tab and complementary feature cooperating to resist shifting from the closed condition to the open condition in the absence of severing of the tab;

the valve element has a port in a top web of the valve element;

a channel is formed along an underside of the top web and extending from the port;

the main body comprises ports; and

the shifting from the closed condition to the open condition rotates the channel into communication with the main body ports.

2. The closure of claim **1** wherein:

the tab is a radially-projecting tab on the valve element; and

in the initial condition, contact between at least one edge of the tab and the complementary feature resists said shifting.

3. The closure of claim **1** wherein:

the shifting is a bi-directional rotation;

the tab is a radially-projecting tab on the valve element; and

the complementary feature comprises a gap in a rim portion of the main body.

4. The closure of claim **3** wherein:

the tab and the complementary feature cooperate to resist said shifting from the closed condition to the open condition in the absence of said severing of the tab so that said severing of the tab disengages the tab from the complementary feature and permits the shifting from the closed condition to the open condition.

5. The closure of claim 1 wherein:
the tab and the complementary feature cooperate to resist said shifting from the closed condition to the open condition in the absence of said severing of the tab so that said severing of the tab disengages the tab from the complementary feature and permits the shifting from the closed condition to the open condition.
6. The closure of claim 1 wherein:
the tab is a radially-projecting tab on the valve element;
the complementary feature comprises a recess; and
in the initial condition, the tab is accommodated in the recess.
7. The closure of claim 1 wherein:
the tab has an upper surface having instruction first indicia indicating that the tab must be torn or pulled off; and
in the initial condition, the main body has, below the tab, second indicia providing instructions to open the valve by bidirectional rotation, the second indicia being revealed by removal of the tab.
8. A bottle comprising:
the closure of claim 1 in the initial condition; and
a bottle body having an externally threaded neck threadingly engaged to the internally-threaded sidewall of the main body.
9. A bottle comprising:
a bottle closure comprising:
a main body comprising a first piece having an internally-threaded sidewall for engaging a bottle external thread; and
a valve element comprising a second piece mounted to the main body for shifting between open and closed conditions, wherein:
in an initial condition, a first of the main body first piece and valve element second piece has an integrally formed tab engaged by a complementary feature of the other of the main body first piece and valve element second piece, the tab and complementary feature cooperating to resist shifting from the closed condition to the open condition in the absence of severing of the tab; and
a bottle body having an externally threaded neck threadingly engaged to the internally-threaded sidewall of the main body,
wherein:
the main body comprises:
a shoulder, the sidewall extending from a rim to the shoulder;
a neck extending upward from the shoulder; and
a top web, the neck extending to the top web and having a pair of radially opposed ports and having a radially-projecting retaining rib retaining the valve element; and
the valve element comprises:
a sidewall; and
a top web at the upper end of the sidewall and having a central aperture, an underside, and a channel along the underside from the aperture,
wherein:
in the closed condition, the closure is sealed by cooperation of the main body top web and valve element top web and, in the open condition, the channel is in alignment/communication with the ports.
10. A bottle closure comprising:
a main body having an internally-threaded sidewall for engaging a bottle external thread; and
a valve element mounted to the main body for shifting between open and closed conditions,
wherein:
in an initial condition, a first of the main body and valve element has an integrally formed tab engaged by a complementary feature of the other of the main body and valve element, the tab and complementary feature cooperating to resist shifting from the closed condition to the open condition in the absence of severing of the tab;
the tab has an upper surface having instruction first indicia indicating that the tab must be torn or pulled off; and
in the initial condition, the main body has, below the tab, second indicia providing instructions to open the valve by bidirectional rotation, the second indicia being revealed by removal of the tab.
11. A bottle closure comprising:
a main body comprising a first piece having an internally-threaded sidewall for engaging a bottle external thread; and
a valve element comprising a second piece mounted to the main body for shifting between open and closed conditions,
wherein:
in an initial condition, a first of the main body first piece and valve element second piece has an integrally formed tab engaged by a complementary feature of the other of the main body first piece and valve element second piece, the tab and complementary feature cooperating to resist shifting from the closed condition to the open condition in the absence of severing of the tab;
the tab has an upper surface having instruction first indicia indicating that the tab must be torn or pulled off; and
in the initial condition, the main body has, below the tab, second indicia providing instructions to open the valve by bidirectional rotation, the second indicia being revealed by removal of the tab.

* * * * *